

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
 690 Walnut Ave.St. 150  
 Vallejo, CA 94592-1133  
 (707) 649-5453  
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000185**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 06-Jul-2007**Location:** Changxing Island, Shanghai, China

**Submittals(New / Total):**      **CWR's:** 0 / 0      **HSR's:** 0 / 0      **NCR's:** 0 / 2

Item	Title	Detail
1	Key conversations	<p>QA observed welding of the following PQR:            HP2007370, 1G GMAW, welding is complete.</p> <p>QA reviewed the following RT film:            PQR HP2007144, rejected due to slag and lack of penetration            PQR HP2007143-1, appeared to be acceptable            6 Welder Qualification Test Plates, 1 plate rejected due to a linear indication.</p> <p>QA physically verified 72 plates for use in production.</p> <p>QA observed MT testing of a bent closed-rib. The testing appeared to comply.</p> <p>QA observed another 2 ribs being bent for the closed-rib demonstration. The first rib did not meet the dimensional tolerances in the Fabrication Procedure. The second rib appeared to comply dimensionally.</p>
2	Meetings attended	<p>QA met with ABF at 1500 to discuss the activities for the weekend.</p> <p>The weekend schedule includes:            Completion of PQR's HP2007149 and HP2007148,            Welding PQR's HP2007247-1 and HP2007249,            Welder qualification testing,            Cutting of material for 77 meter tower mock-up, and            Continuation of material verification it not completed today.</p> <p>ABF on-site QCM Nate Lindell informed ZPMC that there was not a CWI present after lunch for a portion of the PQR welding and that ABF would be issuing a Non-conformance Report.</p> <p>ZPMC stated that they have formed 5 closed-ribs and that only 1 meets the</p>

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requirements of the Fabrication Procedures. QA voiced concern about the current approach to conducting the demonstration. QA believes the intent of the Special Provisions is for the contractor to form 10 closed-ribs, then perform the required dimensional, NDT and destructive testing to prove their bending procedures are satisfactory. ZPMC's current approach of bending then testing until they produce 10 successful rib (not consecutively), does not appear to meet the intent of the Special Provisions. ABF agreed that this is what they also expected to see ZPMC perform the demonstration. ZPMC stated they would be performing internal trials on the rib bending and would inform QA and ABF when they would be ready to perform the demonstration.

QA informed ABF that the production material presented to QA for verification did not provide any separation of material by bid item, and may prove to be an issue during material on hand and progress payments. QA stated he would need to address the issue with the Engineer.

QA addressed concerns regarding the storage of the E9018 electrodes to be used for PQR testing. The electrodes have been removed from the storage oven and left stored outside the oven. ABF stated they would have to look into the issue.

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3      Quality Assurance Inspectors per shift    3 AM (Acuna, Berger, Cuellar)  
0 PM

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**Inspected By:**      McClary,David

Quality Assurance Inspector

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**Reviewed By:**      Lowry,Patrick

QA Reviewer

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